

Wednesday, 21/05/2008 8:51:53 AM  
Linda Lacelle

## Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	OUTBOARD WINDOW DOUBLER
Job Number	3881		Part Number	D37003
Estimate Number	13148		Drawing Number	D3700 PRELIM FOR ENGINEERING USE ONLY
P.O. Number			Project Number	N/A
This Issue	21/05/2008	S.O. No. :	Drawing Revision	PRELIM
Prsht Rev.	NC		Material	:
First Issue	28/04/2008	Type : SMALL /MED FAB	Due Date	05/05/2008 Qty: 1 Um: Each
Previous Run	37134			
Written By				
Checked & Approved By				
Comment	Est Rev:A	08-01-30 new issue DD verified by:EC		

## Additional Product

**PROTOTYPE PRELIMINARY ISSUE**

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet 
		Comment: Qty.: 0.2006 sf(s)/Unit Total : 0.2006 sf(s) 6061T6 aluminium sheet .080" thick (M6061T6S080) Batch: 107276 → 1B 8-5-1 <i>First and scrapd</i> G061T6 S-.080" thick M104186 1B 0805-22
2.0	WATER JET	FLOW WATER JET 
		Comment: FLOW WATER JET 1-Cut as per Dwg D3700 Dwg Rev: PRF L <i>1B 8-5-1</i> <i>1</i> Prog Rev: PRF L
		2- Deburr if necessary <i>1B 8-5-1</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>1B 8-5-1</i>
4.0	QC8	SECOND CHECK  <b>ENGINEERING APPROVAL</b> <i>1 08.05.09</i>
		Comment: SECOND CHECK
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1  Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>Not required</i> <i>1B</i>

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTBOARD WINDOW DOUBLER

Job Number: 38831

Part Number: D37003

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	<i>not required</i>
7.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	Identify and Stock	<i>08.05.21</i>
	Location:	
8.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	<i>08.05.21 Prototype</i>

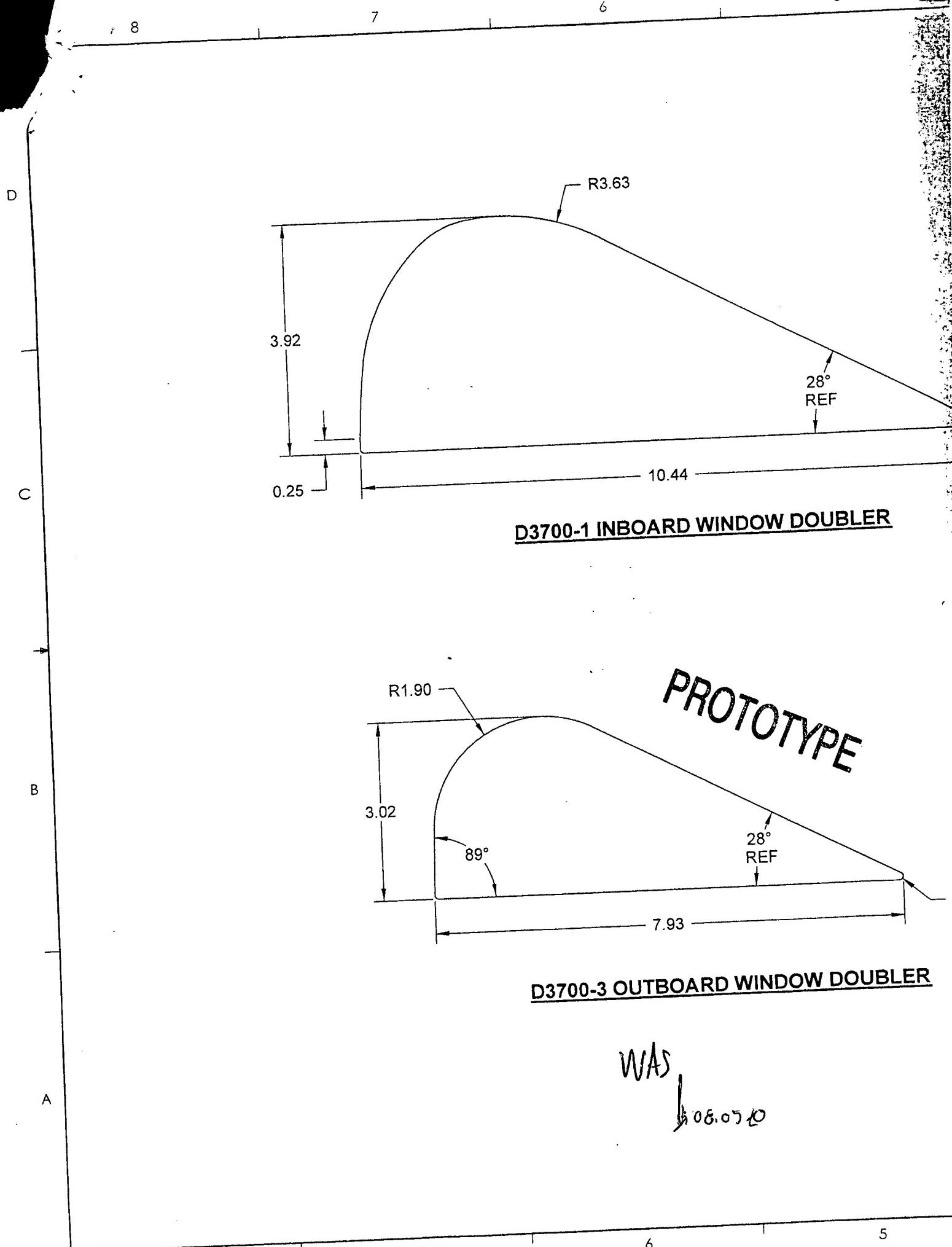
Job Completion



*MF 08-06-13*

PART WAS NOT ADEQUATE -  
MAKE PART AND REVERSE OTHERWISE DRAWS.  
ATTACH NEW DRAWS ON W/O.

*08.05.20*



8 7 6 5 4 3 2 1

D

D

C

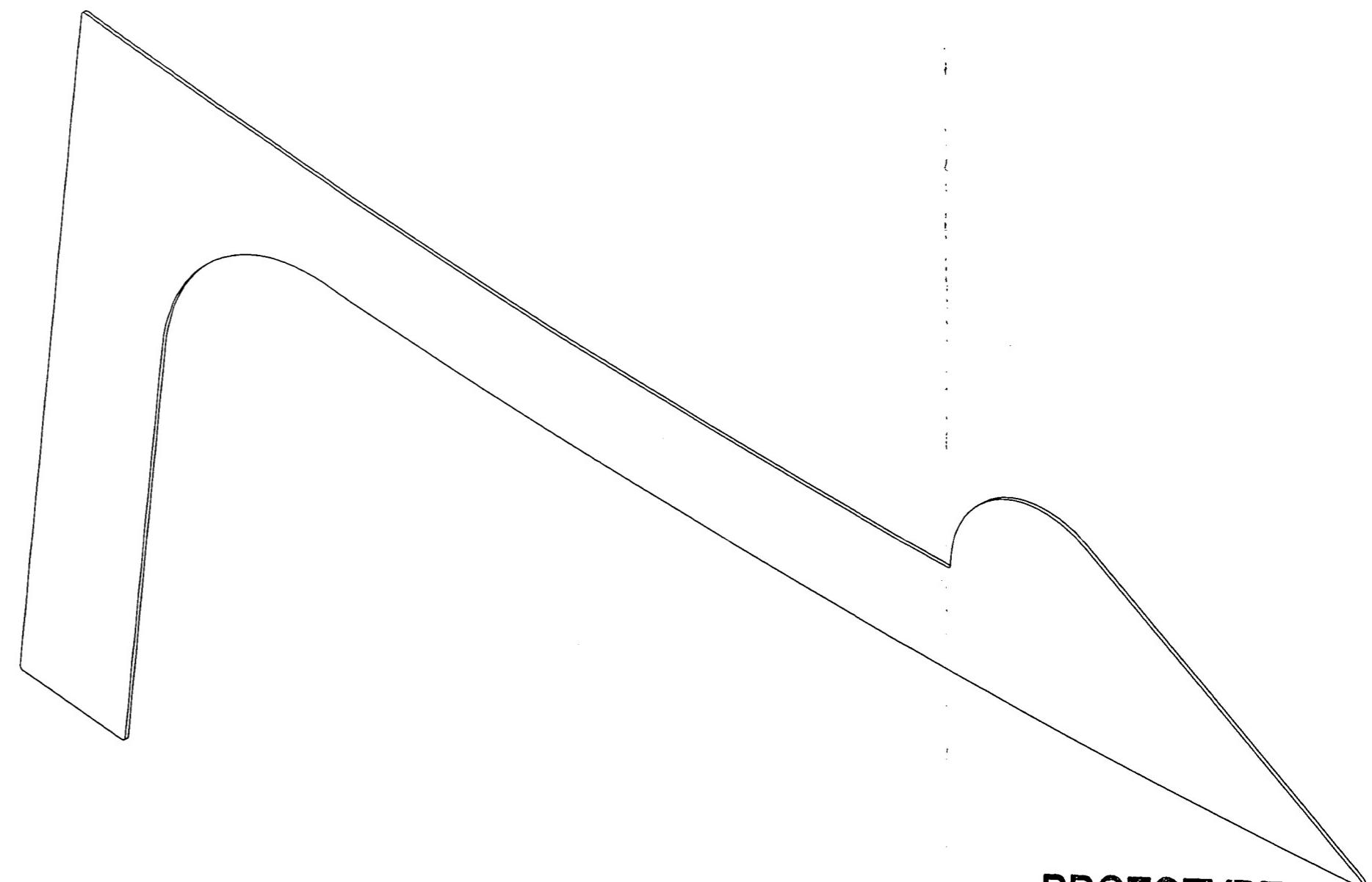
C

B

B

A

A



D3700-1 INBOARD WINDOW DOUBLER

D3700-3 OUTBOARD WINDOW DOUBLER

**PROTOTYPE**

~~PRELIMINARY ISSUE~~  
08-05-20

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3700-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3700-1 = 0.20 lbs  
D3700-3 = 0.45 lbs

A	NEW ISSUE	MB	08.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	!		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.01.29		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3700 REV. A  
SHEET 1 OF 2

TITLE WINDOW DOUBLER  
SCALE NTS

COPYRIGHT © 2008 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1

D

D

C

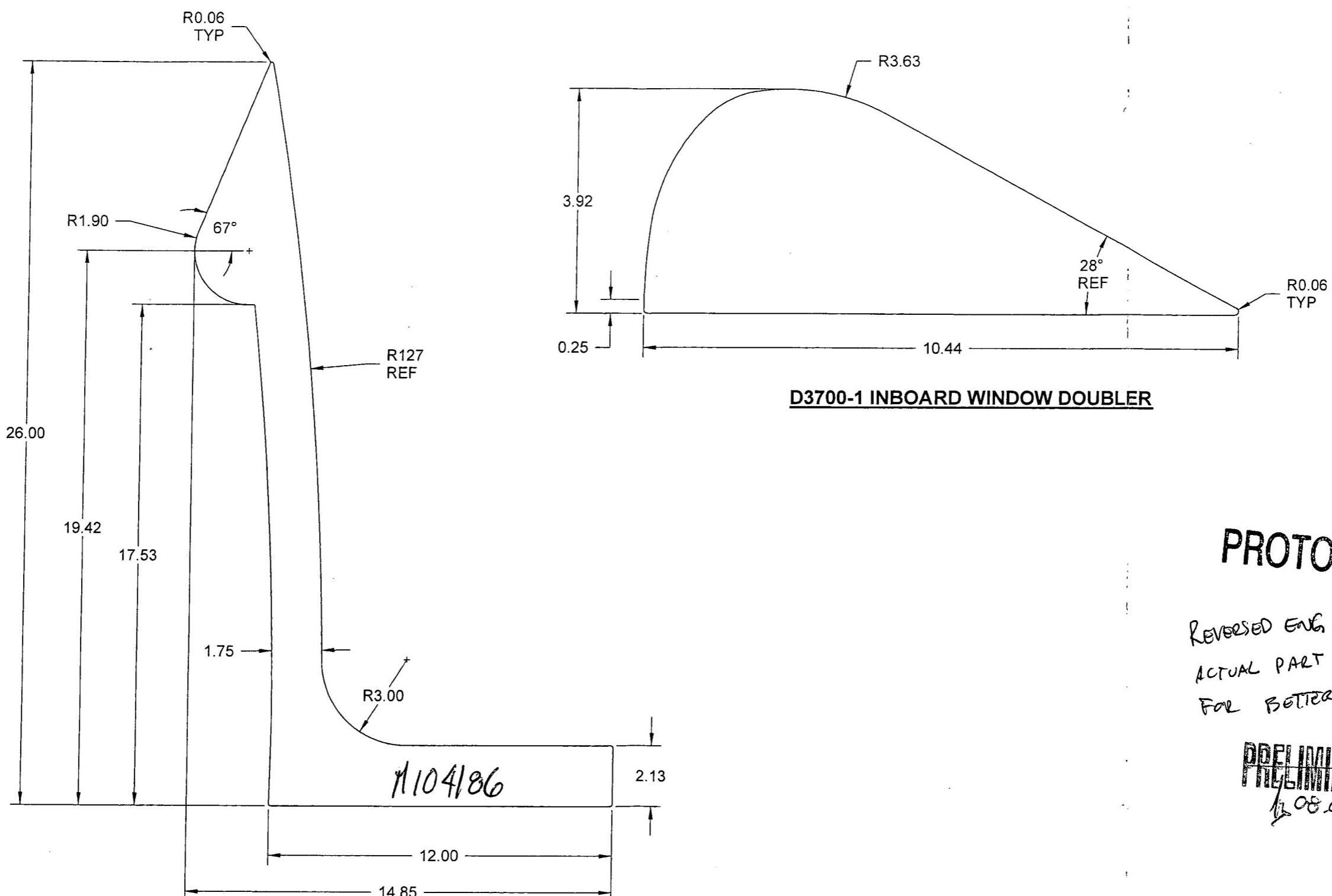
C

B

B

A

A



**PROTOTYPE**

REVERSED ENG. ON  
ACTUAL PART MANUFACTURED  
FOR BETTER FIT. 08.05.21

**PRELIMINARY ISSUE**  
08.05.20

**D3700-3 OUTBOARD WINDOW DOUBLER**

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D3700
APPROVED		TITLE
DE APPR.		WINDOW DOUBLER
DATE	08.01.29	SCALE NTS
COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

## **Receiving Report**

Date: 07/04/20

Batch No: 71041186

Supplier: Magnaghi

Dart P/O: 3581

Packing Slip: Yes  No   
Invoice: Yes  No   
Receipt: Cash  Cr

Release Note Attached: Yes  No  N/A   
Waybill Attached: Yes  No   
Shipment Complete: Yes  No  N/A   
QC6 Inspection  N/A   
Work Order  N/A

### **Discrepancies**

Discrepancies						
Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
	6061-T6 Alum 40 Flat 3/4x3	40	0	0	40	

**Initials of receiver (if shipment OK)** Level 12

### **Production/Admin:**

Date

### **Received/Costing**

Initial

## Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Sub-Total  
G.S.T.

468.00  
28.00

FRAIS D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DÛ.  
LE PRÉSENT CONTRAT SERA RÉGÎ PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME  
AYANT PRIS NAISSANCE DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.  
ADMINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.  
THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD  
BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.

**TOTAL** →

496.08

MAGNA STAINLESS & ALUMINIUM  
 525 MELOCHE AVE.  
 DORVAL, QUEBEC H9P 2W2  
 (514) 631-1211 FAX: (514) 631-0013

 COMM  
 SALES

0147

 VENDU À /  
 SOLD TO:

 LIVRÉ À /  
 SHIP TO:

 DART AEROSPACE LTD  
 1270 ABERDEEN STREET  
 HAWKESBURY  
 ONTARIO

K6A 1K7

INSTRUCTIONS SPÉCIALES / SPECIAL INSTRU

COMMANDE SALES ORDER	CODE DU CLIENT CUSTOMER CODE	BON D'ACHAT DU CLIENT CUSTOMER PURCHASE ORDER	N° DE TÉLÉPHONE DU CLIENT CUSTOMER TELEPHONE NUMBER	N° DE TÉLÉSCOPIEUR DU CLIENT CUSTOMER FAX NO.		
0147704	DART	3581	613 632-5200	632-4443		
LIVRÉ VIA SHIPPED VIA	CONDITIONS / TERMES TERMS & CONDITIONS	DATE COMMANDE DATE ORDERED	DATE REQUISE DATE REQUIRED	DATE LIVRÉE DATE DELIVERED		
OUR TRUCK	NET 30	Apr-19-07	Apr-25-07		15	20
QUALITÉ QUALITY	UNITE UNIT	NO DE COULÉE HEAT NUMBER	DESCRIPTION	QTE LIVRÉE QTY SHIPPED	PRIX PAR PRICE PER	INSTRUCTION PLANT INST.
2 pc 2	PCS	100-73 M104180 M6061T65080	6061-T6 .080 X 48 X 144 <i>EPA/104/180</i>	110#		2 pcs
TOTAL :						

 MTR-AVEC COMMANDE  
 MTR'S-WITH ORDER 

 POSTE  
 MAIL 

 TÉLÉSCOPIEUR  
 FAX 

 N° DE COULÉE ÉTAMPER SUR LE CÔTÉ  
 HEAT NO. STAMP ON END 

20070419

\*\*PACKING SLIP / BON D'EMBALLAGE

ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:

REVISEE

**Novelis Deutschland GmbH, Werk Nachterstedt**  
**Novelis Automotive, Painted & Specialities**

Gaterslebener Straße 1  
D-06469 Nachterstedt

Postfach 1345  
D-06433 Aschersleben

Tel.: (03 47 41) 77-0  
Fax: (03 47 41) 204  
www.novelis.com

47525

|||||||  
Novelis

Abnahmeprüfzeugnis  
Inspection Certificate  
Certificat de Reception

EN 10204-3.1  
EN 10204-3.1  
EN 10204-3.1

Nr./No. 81363840-A

Standard ASME SB209 (1995)

Auftrag-Nr. Order no. No de commande	0000080353	Werkstoff- Alloy- Alliage	6061	Zustand- Temper- Etat	T6	ER-3249-P R118474 E1
Gewicht, netto Weight, net Poids net	14.683 lbs	Stückzahl- Pieces Pièces	4 COLLI	LL-FLAT SHEETS / COMMERCIAL QUALITY		

Chemische Zusammensetzung in Gewichtsprozenten  
Chemical composition in percentage by weight  
Composition chimique en pourcentage de poids

Charg.-Nr./Cast no./No. de coulée

Charg.-Nr./Cast no./No. de coulée	Brand-Nr.	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	
100 100373	05/82751	0,50	0,38	0,27	0,06	0,92	0,07	0,01	0,01	

Mechanische Eigenschaften  
Mechanical properties  
Caractéristiques mécaniques

Pos.	Coll.	Brand-Nr.	Abmessung Dimension Dimension	Prüfrichtung Direction of testing sens de mesure	0,2% Dehngrenze Proof stress Limite d'élasticité à 0,2% $R_{p0,2}$	Zugfestigkeit Tensile strength Résistance à la traction $R_u$	Dehnung Elongation Allongement	Zugel. Elongation Corr. Corr.	
20	2116002	8275100001	2,032 * 1219,20 * 3657,60 mm .080X48X144" ER-3249-P - R118474- 8	Q	270	317	14		
	2116003	8275100002		Q	270	317	14		
	2116004	8275100003		Q	270	317	14		
	2116005	8275100004		Q	270	317	14		

This certificate has been made out by EDP and that's why it isn't signed.

sig. D. Kühne

Werksachverständiger/  
plant specialist

Nachterstedt, 21.11.05

Zertifiziert nach ISO 9001, ISO/TS 16949, ISO 14001, EMAS II, OHSAS 18001  
Sitz: Göttingen (HRB 772), Geschäftsführung: Nikolaus Firk, von Verschuer, Erwin Faust

# Receiving Report

Date:

07/04/20Batch No: 51041186

Supplier:

Magnaghi

Dart P/O:

3581

Packing Slip: Yes  No   
 Invoice: Yes  No   
 Receipt: Cash  Cr

Release Note Attached: Yes  No  N/A   
 Waybill Attached: Yes  No   
 Shipment Complete: Yes  No  N/A   
 QC6 Inspection:   
 Work Order:

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
	6061-T6 Alum 40	40	0	0	40	
	Flat 3/4x3					

Initials of receiver (if shipment OK) JL Level 12 SP

Production/Admin:

Date

Received/Costing

Initial

07/04/20  
R/P 4401-4417

Location \_\_\_\_\_

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Sub-Total  
G.S.T.468.  
28.

TOTAL ➔

496.  
00

FRAIS D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DÜ.  
 LE PRÉSENT CONTRAT SERA RÉGI PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME  
 AYANT PRIS NAissance DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.  
 ADMINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.  
 THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD  
 BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.

卷之三

યાજ્ઞ

416 213 9507 Pax Servit

Page 64

**Novafis Deutschland GmbH Werk Nachbarscheid  
Novafis Automotive, Painted & Specialties**

प्राचीन विद्यालय के अधिकारी ने इसका उत्तर दिया है।

ପ୍ରକାଶନ କେନ୍ଦ୍ର

Novelis

१५८

卷之三

卷之三

Standard

卷之三

BR-3249-2 R1974 E

प्रसादित्याकृतोऽपि विश्वामी

प्रसादीकामिनी

This certificate has been made out by me and hasn't been signed.

Zentrale Stelle für den Export und Import der DDR, Postfach 11850, 1000 Berlin 10, Telefon 030/945-14001

संग्रह